

1652



Dart Aerospace Ltd.
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Canada

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RBE350A93-3305-20-1**Job Sheet 173894**

Part No: RBE350A93-3305-20-1

Job Qty: 1 ea

Part Name: Tail Gearbox Wrench



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 3/8/18

Job Tracking No:

Due Date: 5/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A93-3305-20-1 REV:C IPP REV A 18.01.23 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

Bill of Materials**Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	6 Ea	5/28/18	5/28/18	0.00	0.00	Start Up Machining-4			DAS 56 9-89 2018-07-15
100	Mori Seiki	6 pcs	5/28/18	5/28/18	0.00	12.00	MORI SL2500Y			
110	QC	6 pcs	5/28/18	5/28/18	0.00	0.00	QC2 Machining-5			
115	Mori Seiki	6 pcs	5/28/18	5/28/18	0.00	0.00	MORI NV5000-1			
120	QC	6 pcs	5/28/18	5/28/18	0.00	0.00	QC2 Machining-2			
130	QC	6 pcs	5/28/18	5/28/18	0.00	0.00	QC8 Machining-5			
230	Packaging	6 pcs	5/28/18	5/28/18	0.00	0.00	Packaging3-2			
240	QC21-SA	6 Ea	5/28/18	5/28/18	0.00	0.00	QC21			

Part Op 100 - 1-Machine as per folio FB876 FOLIO REV: RA DWG REV: C 2-Broach as per dwg. 3-Descriptions: Deburr

115 - 1-Machine as per folio FB876 FOLIO REV: _____ DWG REV: _____ 2-Engrave T number as per DWG. program B877AA03.NCC 3-Deburr

230 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R1.375	17-4 SS H900 Round Bar 1.375"	.6960 ft (.116 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H900-R1.375	1	8	0

Part Specifications

Specifications could not be found.



Container No: S089426



Part: RBE350A93-3305-20-1

Job No: 173894

Serial No/Batch: S089426

Revision: C

Inspector:

Exp Date:

Instructions:

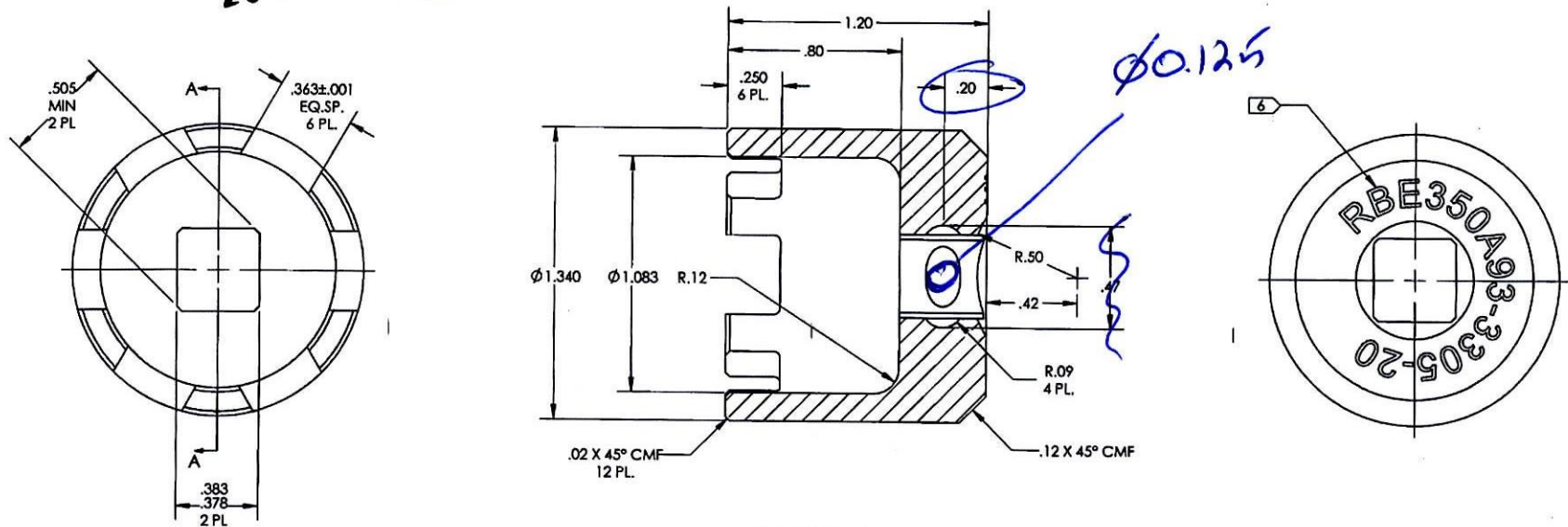
Date: 07/05/18

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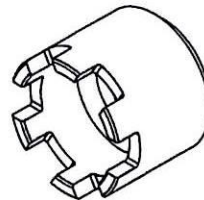
Plex 6/19/18 10:45 AM dart.logan.david

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173899
20180619

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
C	PART NUMBER -1 ADDED AT THE END, TOLERANCE ON DIMENSION .363" CHANGED FOR .363" $\pm .001$ ", ENGRAVING CHANGED FOR MACHINE ENGRAVE, VIEWS CHANGED FOR CLARITY	17-798	17.12.21	VM	ML



SECTION A-A



RBE350A93-3305-20-1 TAIL GEARBOX WRENCH

NOTES:

- 1) MATERIAL: 17-4 PH-H900 SS
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: MACHINE ENGRAVE AS SHOWN, 0.010" DEEP

DART AEROSPACE		Hawthornbury, Ontario, Canada	
TITLE TAIL GEARBOX WRENCH			
PART NO. RBE350A93-3305-20-1		REV C	
TOOL NO. RBE350A93-3305-20			
DESIGNED BY: VM 17/12/21		TOLERANCES: UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING	
DRAWN BY: VM 12/27/2017		X.XX 2.008 FRACTIONS 2 1/8	
CHECKED BY: VM 01/02/2018		X.X 2.1 ANOLES 2.5"	
MFG REVIEW BY: DD 01/02/2018		X 2.1 SURFACE ROUGHNESS	
APPROVED BY: ML 01/04/2018		SCALE: NTS SHEET 3 OF 6	
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>173894</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>RBB350A93-3305-20-1</u>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Large Fab ☐	Composite ☐	Supplier ☐		
Date : _____	Step #: _____	QTY Effective : _____			MRB (QSI042) Approval <i>[Signature]</i>

Description Work Order Deviation QTY (1) Ø0.125 HOLE HAS BEEN DRILLED 0.20 FROM FACE AS SHOWN ON ATTACHED DRAWINGS, IN PLACE OF THE 0.470 GROOVE.	Disposition THIS DEVIATION IS ACCEPTABLE. NO CHANGE TO SET, FORM OR FUNCTION.	JULY 18/18 Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☒ Process Improvement ☒ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					